

Work Order ID 128582***128582***

Page 1

Monday, January 19, 2015 2:48:12 PM

Item ID: D4008-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Filler Splash Guard Assembly
Start Date: 1/19/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/30/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference: REWORK PER ECN 14-666

Approvals: Process Plan: mf Date: 15-1-19 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4008	E								

220

0.00

220

QC

Quality Control

Memo

0.00

PULL FROM STOCK D4008-041 X 4 B107372

STRIP, PRIME AND SPRAY PAINT PER ECN 14-666

4x _____ CR 15-03-05

230

0.00

230

Small Fab

Small Fab

Memo

0.00

REMOVE AND SCRAP PARTS FROM D4008-1

BRING TO FINISHING FOR STRIPPING

4x _____ 15/01/23 **DAS**
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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128582

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Revision ID:					Stop	*NS2*
Item Name:	Fuel Filler Splash Guard Assembly					
Start Date:	1/19/2015	Start Qty:	4.00	*4*	Cust Item ID:	
Required Date:	1/30/2015	Req'd Qty:	4.00	*4*	Customer:	
Reference:	REWORK PER ECN 14-666					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240		0.00				1			
240									
SprayPaint	Memo	0.00							
Spray Painting	***REMOVE PIN PRIOR TO PRIME AND PAINT***								
	1- PRIME TEMPO GREY (4.2.1.3.2) AS PER DWG								
	PRIMER BATCH: <u>M130313</u>								
	2- PAINT FLAT GREY (4.2.2.3) AS PER DWG								
	PAINT BATCH: <u>M127810</u>								
250	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
250									
QC	Memo	0.00							
Quality Control									

MAR 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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0.00

Packaging

DQA: _____ Date: _____



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Work Order ID 128582

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128582

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Revision ID: Stop ***NS2***
Item Name: Fuel Filler Splash Guard Assembly
Start Date: 1/19/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/30/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference: REWORK PER ECN 14-666

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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290

QC21- Final Inspection - Work Order Release

0.00

290

QC

Memo

0.00

Quality Control

MUS 1503-06

PS.3.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Monday, January 19, 2015 2:48:11 PM

Page 1

Work Order ID: 128582

128582

Parent Item: D4008-041

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 1/19/2015

Required Date: 1/30/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07
AS PER DWG REV.C DD VERF:EC IPP REV:D 15.01.05 AS PER
DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3941 *D3941* Rubber Cushion		Manufactured	No				f	10.5300		0.84	DAS 36 9-89		
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			10.53						
				48512			10.53						
D4008-041 *D4008-041* Fuel Filler Splash Guard Assembly		Manufactured	No				Each	6.0000		4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST249A			6						
				123109			4						
				124463			2						
D4008-5 *D4008-5* Fuel Filler Splash Guard Hinge Half		Manufactured	No				Each	5.0000		4			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			5						
				106474			5						
D4008-7 *D4008-7* Washer		Manufactured	No				Each	45.0000		8			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			45						
				106676			45						

DAS
36
9-89

DAS
36
9-89

DAS
36
9-89

B127244 (12)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Process									
Supplier									
Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Page 2

Work Order ID: 128582

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Parent Item: D4008-041

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 1/19/2015

Required Date: 1/30/2015

Start Qty: 4.00

Required Qty: 4.00

D4008-9

Manufactured No

Each

26.0000

4

D4008-9

Spring

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

26

106510

6

122478

20

f

6.0000

4

DAS
36
9-89

MS20001-4

Purchased

No

MS20001-4

Pin

Location

Loc Qty

Loc Code

ST479a

6

M130922

6

Each

6,800.000

20

15/03/03

DAS
36
9-89

MS20470AD3-3

Purchased

No

MS20470AD3-3

RIVET, UNIVERSAL HEAD

Location

Loc Qty

Loc Code

GA

1080

1065

1080

ST311

5720

16941

5720

Each

753.0000

8

DAS
36
9-89

MS21042L08

Purchased

No

MS21042L08

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

652

123900

16

m128401

210

m130325

426

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Shop Packet Print

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FAULT CATEGORY

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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Monday, January 19, 2015 2:48:12 PM

Page 3

Work Order ID: 128582

128582

Parent Item: D4008-041

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 1/19/2015

Required Date: 1/30/2015

Start Qty: 4.00

Required Qty: 4.00

MS35206-S245

Purchased

No

Each

175.0000

8

MS35206-S245

Screw

DAS
36
9-89

Location

Loc Qty

Loc Code

ST276

175

m127432

175

Each

610.0000

24

NAS1149DN832J

Purchased

No

NAS1149DN832.J

Washer

DAS
36
9-89

Location

Loc Qty

Loc Code

MF4

185

M129541

185

ST270

425

124555

59

M128429

282

M129499

84

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

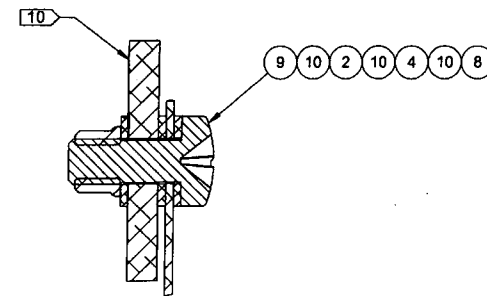
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

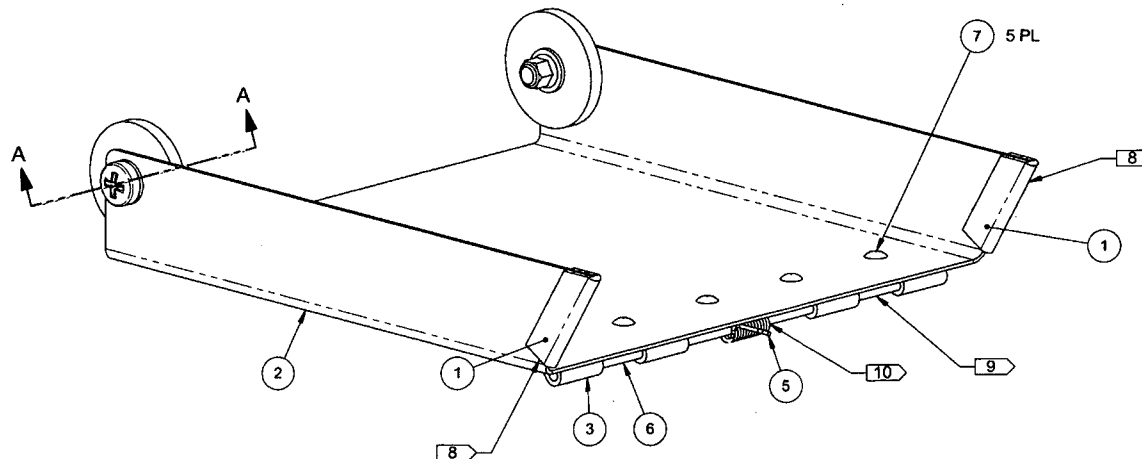
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
1	2	D3941-1	RUBBER CUSHION	
2	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
3	1	D4008-5	HINGE HALF	
4	2	D4008-7	WASHER	
5	1	D4008-9	SPRING	
6	1	MS20001-4	PIN	
7	5	MS20470AD3-3	RIVET	
8	2	MS21042L08	NUT	
9	2	MS35206S245	SCREW	
10	6	NAS1149DN832J	WASHER	



SECTION A-A
SCALE 2X
2 PL



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SIKAFLEX ADHESIVE, TRIM TO FIT, AFTER PRIME AND PAINT
- 9) MASK HINGE PIN AREA BEFORE PRIME AND PAINT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER PRIME AND PAINT

RELEASED

2015 JAN 15

ECN 14-666

E	REVISED FINISH ON SHT 1 & 5; REDRAW SECTION A-A SHT 1; RE-ORGANIZED ITEM NUMBERS (SHT 1 & 2); ADDED MISSING DIMS ON D4008-5; MS21059L3 WAS MS21059L4 (SHT 2); INCREASED VIEW SIZES ON SHT 2, 3, 5; ADDED NOTE 8 (SHT 5); REMOVED DIMPLING NOTE FROM SHT 6	AP	14.12.05
D	ADDED RIVET HOLES TO D4008-11 (C7-10) UPDATED NOTES ON ALL SHEETS	ML	14.05.13
C	CHANGE POWDER COAT FROM "GREY SANDEX" TO "ANSI 61 GREY"; CORRECT MATERIAL ERROR, ZN A7-6. ADD D4597-1 TO D4008-043, ZN C4-2.	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4008 SHEET 1 OF 10 TITLE SPLASH GUARD SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AP		
CHECKED	DB		
MFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS	DATE 14.12.05	

APPROVED

#128562

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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